



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6505G00151-3G-PO

Job Sheet 183473



Part No: RBW6505G00151-3G-PO **Job Qty:** 4 ea

Part Name: Tail Rotor Gear Box Lift - Eye Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/9/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6505G00151-3G Rev 2 IPP Rev A outsource 18.09.18 DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	4 pcs	10/9/18	10/9/18	0.00	0.00	Purchasing		<i>[Signature]</i> OCT 05 2018
110	Packaging	4 pcs	10/9/18	10/9/18	0.00	0.00	Packaging2		<i>[Signature]</i> OCT 05 2018
120	QC	4 pcs	10/9/18	10/9/18	0.00	0.00	QC6		38
130	Small Fab	4 pcs	10/9/18	10/9/18	0.00	0.67	Small Fab-4		<i>ML</i> <i>DAS</i> <i>Lead test</i> <i>181010</i>
140	QC	4 pcs	10/9/18	10/9/18	0.00	0.00	QC5		<i>Dag</i> 38
150	Packaging	4 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3-1		<i>21</i> 9-89
160	QC21-FG	4 Ea	10/9/18	10/9/18	0.00	0.00	QC21		<i>3-89</i> <i>OCT 11 11:11 AM</i>

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 040154 MANUFACTURE RBW6505G00151-3G AS PER Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Fabricate lanyard and attach Dart placard RB41011 into RBW6505G00151-3G as per DWG.

P0041054 x 4 Set 18.2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6505G00151-3GP	Lift Eye Tail Rotor Gear Box	4 Ea (1 ea)	100-Purchasing	<i>5116228</i>
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (1 ea)	130-Small Fab	<i>5109072</i>
CL-2-C	Lanyard Wire	.2000 ft (.05 ea)	130-Small Fab	<i>5093863</i>
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	130-Small Fab	<i>5021040</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6505G00151-3GP	4	0	0
130-Small Fab	3896T31	4	1,033	0
	CL-2-C	0	348	0
	RB41011	4	778	0

Part Specifications

Specifications could not be found.



Container No: S116229



Part: RBW6505G00151-3G

Job No: 183473

Serial No/Batch: S116229

Revision: 2

Inspector:

Exp Date:

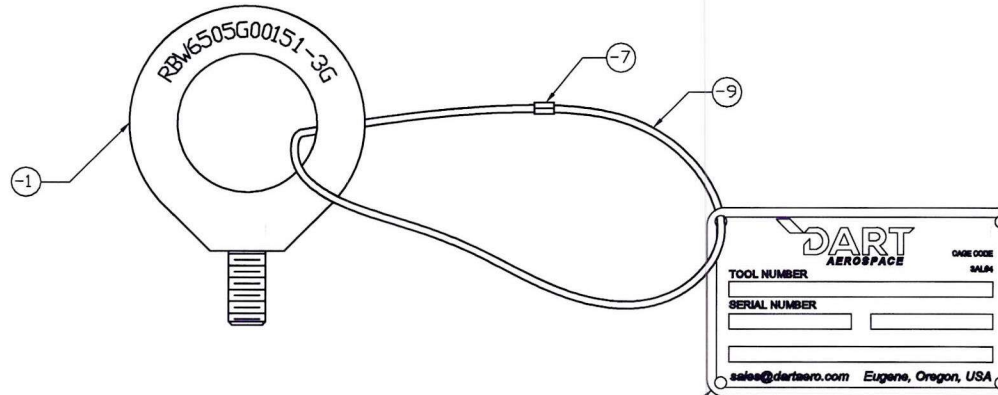
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/05/16

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D ENGRAVE NOTE -3 PER DW, CH'D -3 HEIGHT FROM 2.075 TO 2.027 PER GE.	4/8/11	RJC	
2	-3 AND -5 CORRECTED THREAD CALLOUT WAS 5/16-18 UNC IS 5/16-24 UNF.	4/8/14	RJC	RW



CH'D CUSTOMER SHEETS TO REV 3 W/
DART. WAITING FOR REV TO COME BACK
TO FINISH.

DAN 2/16/2015

NOTE:

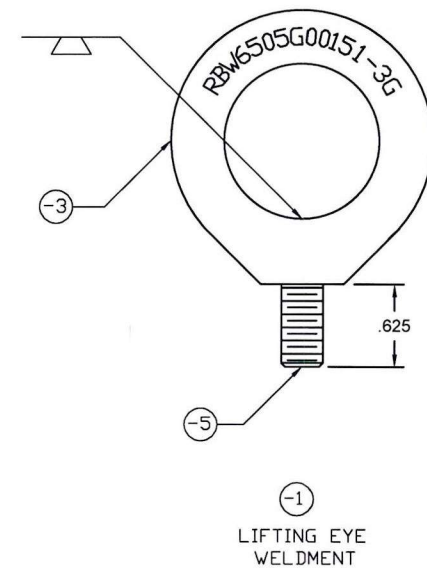
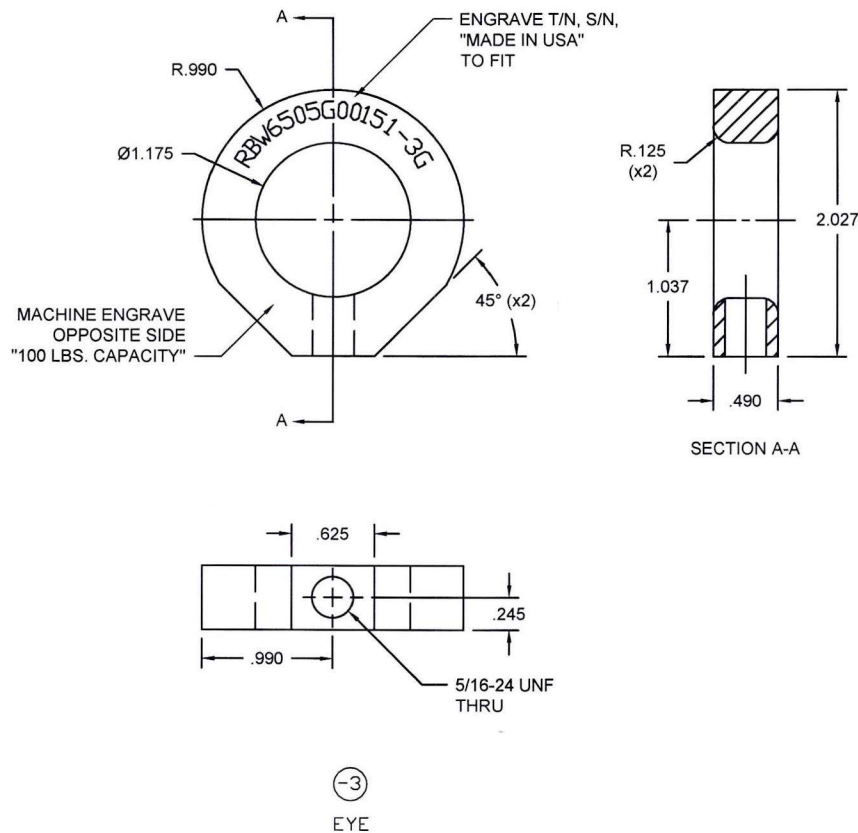
1. LIFTING EYE ASSY. 100 LBS. CAPACITY.
2. LOAD TEST AT 150 LBS. PER INSPECTION & TESTING PROCEDURES.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LIFTING EYE ASSY.			2
	1		-3		EYE	4140	1/2 x 2-1/8 x 2-1/4	2
	1	B/O	-5		SOCKET HEAD SET SCREW	STEEL	5/16-24 UNF x 1 MCMaster-CARR #91375A604	2
		B/O	-7	1	OVAl COMPRESSION SLEEVE	ALUMINUM	Ø1/16 x 3/8 MCMaster-CARR #3896T31	1
		B/O	-9	1	COATED LANYARD CABLE	GALV. STEEL	(7x7 CABLE) Ø1/16 x 6in. CARR LANE #CL-2-C-6.0in.	1
		B/O	-11	1	RED BARN PLACARD		RB41009	1
ASSY	-1							

RED BARN MACHINE	
TITLE LIFT EYE T/R G/B	
DWG NO. RBW6505G00151-3G	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5/17/10
SHEET 1 of 4	

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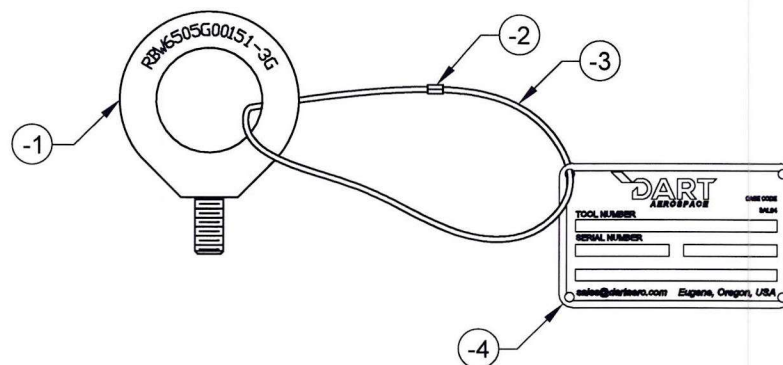
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D ENGRAVE NOTE -3 PER DW, CH'D -3 HEIGHT FROM 2.075 TO 2.027 PER GE.	4/8/11	RJC
2	-3 CORRECTED THREAD CALLOUT WAS 5/16-18 UNC IS 5/16-24 UNF.	4/8/14	RJC



NOTES:
1. INSTALL SOCKET END OF SET SCREW-5 INTO -3 AND PLUG WELD.

RED BARN MACHINE	
TITLE LIFT EYE T/R G/B	
DWG NO. RBW6505G00151-3G	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5/17/10
SHEET 2 of 4	
DRAWN BY: CLOUGH	
APPROVED <i>D Weil</i>	
HEAT TREAT FINISH POWDER COAT RED	
SPEC RAL 3020	
USED ON MODEL AW139	

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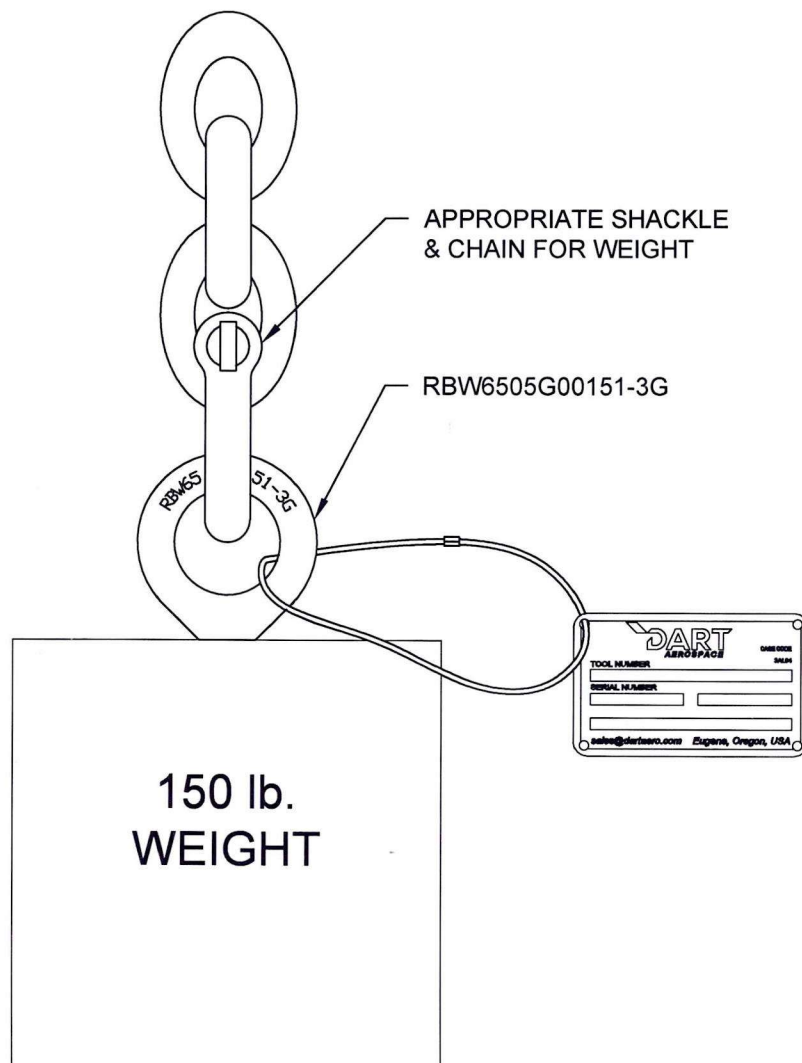


ASSEMBLY

PART #	QTY	DESCRIPTION
-1	1	LIFTING EYE
-2	1	ALUMINUM FERRULE
-3	1	COATED LANYARD CABLE
-4	1	PLACARD

DART AEROSPACE 190 South Danebo Ave Eugene, Oregon 97402 1-541-344-9953 e-mail: sales@dartaero.com dartaerospace.com		
TITLE LIFT EYE T/R G/B		
DWG NO. RBW6505G00151-3G	REV 3	CUSTOMER 1 of 2
SCALE 1:2	DATE 5/17/10	SHEET 3 of 4

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INSPECTION & TESTING PROCEDURES FOR THE RBW6505G00151-3G LIFTING EYE ASSEMBLY. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

91 DAY INSPECTIONS

1. CLEAN ENTIRE UNIT AND REMOVE CORROSION.
2. CHECK THE EYE FOR STRESS CRACKS, BENDING, OR DISTORTIONS.
3. CHECK SET SCREW FOR DAMAGED THREADS, STRESS CRACKS, STRETCHING OR DISTORTIONS.
4. REPAINT IF NECESSARY.

IF ANY OF THE ABOVE CONDITIONS EXIST, OR ARE SUSPECTED OF EXISTING. DO NOT USE THE TOOL UNTIL IT HAS BEEN REPAIRED AND TESTED OR REPLACED.

3 YEAR WEIGHT TESTING

1. AFTER INSPECTION, SECURELY FASTEN THE RBW6505G00151-3G LIFTING EYE ASSEMBLY TO THE APPROPRIATE SHACKLE & CHAIN FOR TESTING.
2. USING THE APPROPRIATE SHACKLES AND CHAINS (500 lb. MINIMUM PREFERRED), ATTACH THE LIFTING EYE TO A 150 lb. TESTING WEIGHT.
3. CAREFULLY LIFT THE ATTACHED ASSEMBLIES UNTIL THE TESTING WEIGHT IS APPROXIMATELY 1 FOOT OFF THE GROUND.
4. LEAVE THE WEIGHT SUSPENDED FOR 5 MINUTES. WHILE THE WEIGHT IS SUSPENDED CAREFULLY OBSERVE THE RBW6505G00151-3G LIFTING EYE ASSY. FOR ANY DEFLECTION AND DISTORTIONS.
5. AFTER 5 MINUTES, LOWER AND DISCONNECT THE TESTING WEIGHT, SHACKLES, AND CHAINS.
6. RE-INSPECT THE ENTIRE RBW6505G00151-3G LIFTING EYE ASSEMBLY.



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TITLE

LIFT EYE T/R G/B

DWG NO.

RBW6505G00151-3G

REV

3

CUSTOMER

2 of 2

SCALE

1:2

DATE

5/17/10

SHEET

4 of 4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041054

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041054
PO Date: 9/18/18
Due Date: 10/9/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Revision

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	183473	RBW6505G00151-3GP			Lift Eye Tail Rotor Gear Box	Firmed	-	10/9/18	4 Ea	0 Ea	4 Ea	\$214.54/Ea	\$858.16
Line Item Note REV 2													
2	183474	RBW6205G09132-3GP			Trolley Adapter, Swashplate Support	Firmed	-	10/9/18	2 pcs	0 pcs	2 pcs	\$2,698.00/pcs	\$5,396.00
Line Item Note REV 3													
												Grand Total:	\$6,254.16

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/28/18 9:06 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Customer Packing Slip

NO: 275

Date: 10/04/2018 ✓
PO Ref: 041054 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Qty	Item	Part No.
4 ✓	Lift eye tail rotor gear box	RBW6505G00151-3GP ✓

DAS
38
9-88

Packaged by: P.E.
Checked by: MA

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:041054 ✓ Dated: 10/04/2018

Our Order / Job No:091818 DAWT Order Qty:4 ✓

Part Name:LIFT EYE TAIL ROTOR GEAR BOX

Part Number: RBW6505G00151-3G

Lot Size:N/A Ship Date: 10/04/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6505G00151-3G ✓ Rev:2

Material Size and Type: 4140

Material Specifications: ASTM A108, ASTM A29

Heat Treatment:N/A

Plating/Finish: POWDER COAT RED RAL 3020

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 10/04/18

Signed: Herman Ralt

DAS
38
9-89

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